

Date: Monday, 3/19/2007 8:13:27 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: EYEBALL ADAPTER
Job Number	: 31260		
Estimate Number	: 12244		
P.O. Number	: N/A	Part Number	: D3480043
This Issue	: 3/19/2007 S.O. No. : N/A	Drawing Number	: D3480 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 28530	Material	: N/A
Written By	:	Due Date	: 3/23/2007 Qty: 4 Um: Each
Checked & Approved By	: <u>07.03.19</u>		
Comment	: est rev. A 06.02.07 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34801	Flange
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
X 1	D3480-1	Flange	B31280-

2.0	NAS1031C3W	Nutplate
-----	------------	----------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
4	NAS1031C3W	Nutplate	m101144-

mf 07-03-21

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Spot weld as per dwg D3480

mf 07-03-21

4.0	QC11	VISUAL INSPECTION OF SPOT WELDING
-----	------	-----------------------------------



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/03/22

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

SB 07/03/22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LR Date: 27/03/2016
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 8:13:28 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EYEBALL ADAPTER

Job Number: 31260

Part Number: D3480043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: _____

7/63/23

7/63/23

521

(4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

7/63/26

Job Completion



U of 03.26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

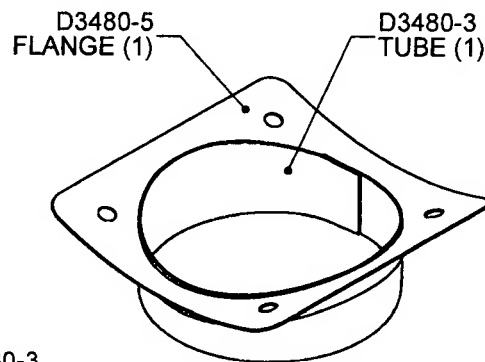
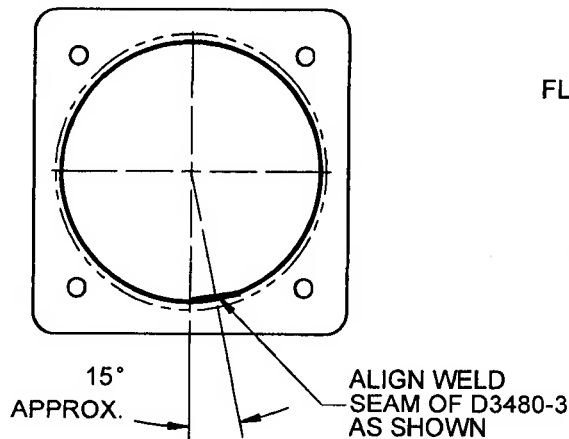
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

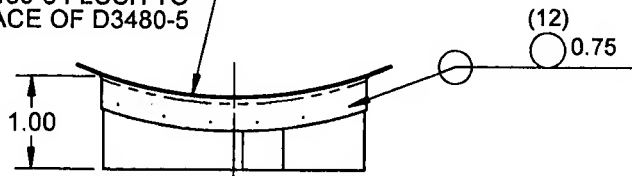
NOTE: Date & initial all entries

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CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D3480	REV. B SHEET 1 OF 6
DATE 06.08.29		TITLE EYEBALL ADAPTER	SCALE 1:2
A	06.02.06	NEW ISSUE	
B	06.08.29	D3480-3 0.50 was 0.40/D3480-3F 8.930 was 9.330	



SPOT WELD PARTS, THEN
CUT D3480-3 FLUSH TO
SURFACE OF D3480-5



D3480-041 EYEBALL INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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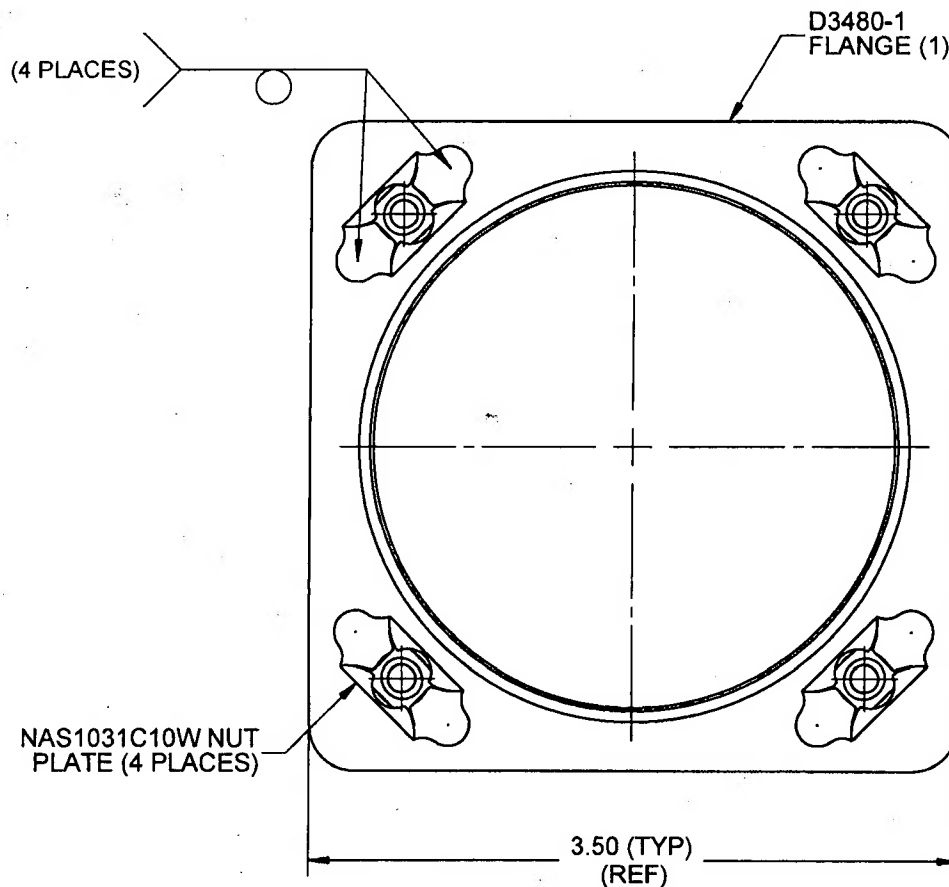
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DATE 06.08.29		TITLE EYEBALL ADAPTER SCALE 1:1	

RELEASED06.09.19 *[Signature]***D3480-043 EYEBALL ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

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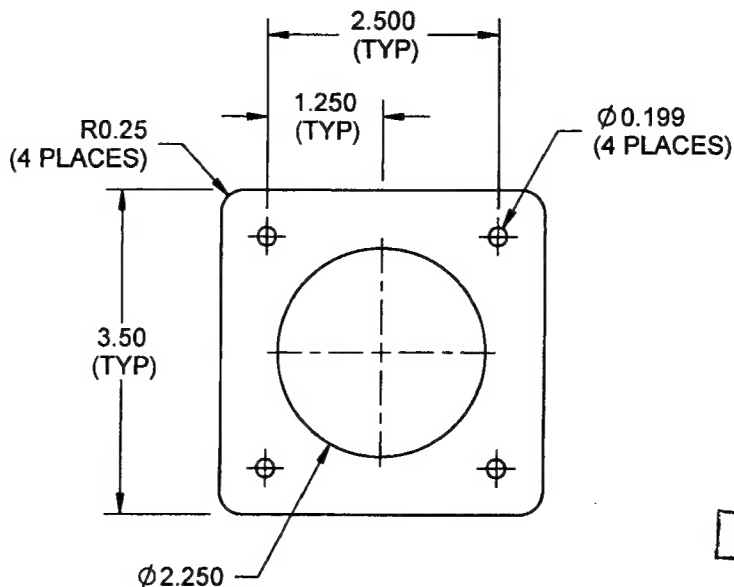
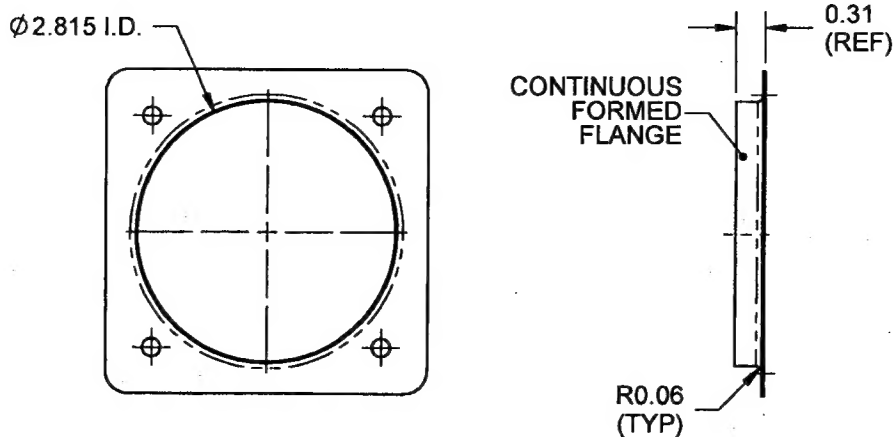
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DATE 06.08.29		TITLE EYEBALL ADAPTER	SHEET 3 OF 6 SCALE 1:2

**RELEASED**06.09.19 *H***D3480-1F FLAT PATTERN****D3480-1 FLANGE**
(MAKE FROM D3480-1F)**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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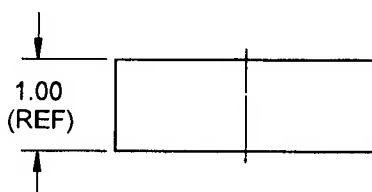
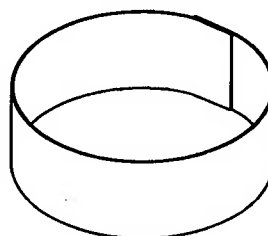
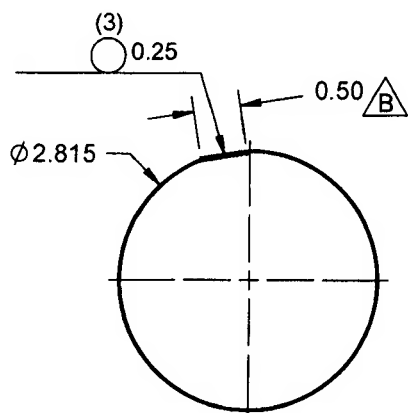
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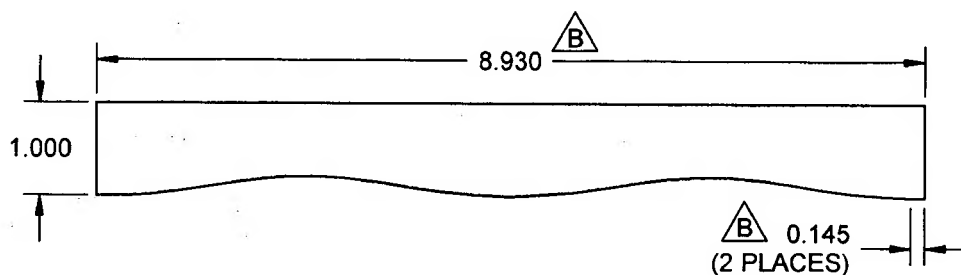
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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3480	REV. B SHEET 4 OF 6
DATE 06.08.29		TITLE EYEBALL ADAPTER	SCALE 1:2



RELEASED

06.09.19 *PH*

D3480-3 TUBE



D3480-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

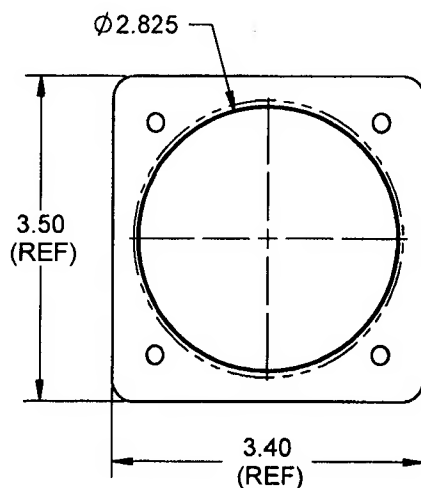
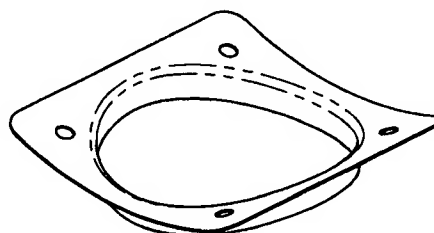
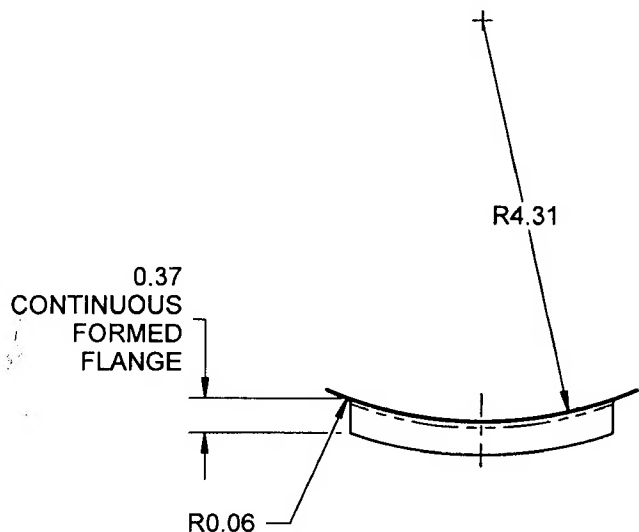
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DATE 06.08.29		TITLE EYEBALL ADAPTER	SHEET 5 OF 6 SCALE 1:2



RELEASED
06.09.19 *H*

D3480-5 EYEBALL ADAPTER FLANGE

NOTES:

- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

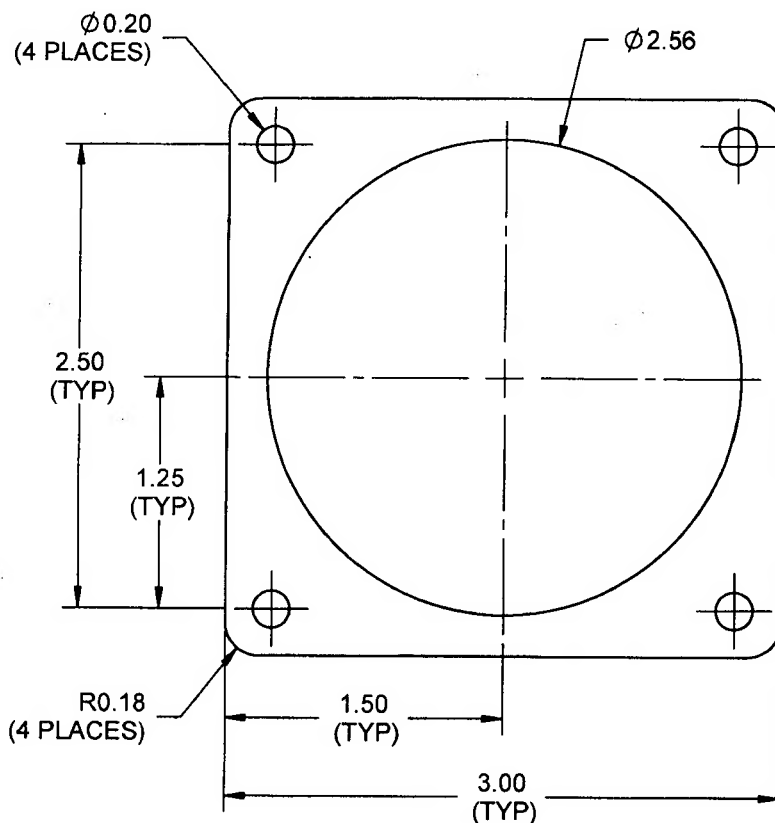
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DATE 06.08.29		TITLE EYEBALL ADAPTER	SHEET 6 OF 6 SCALE 1:1



RELEASED

06-09-19 *PH***D3480-7 GASKET****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.125" THICK (REF. DART SPEC. M-SIL60-.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO: 2

EMPLOYEE: Melanie Fautan

PART NUMBER: D3180-043

JOB NUMBER: B 31260

MATERIAL TYPE: 304/316 SS

MATERIAL THICKNESS: 24G

GROUP SPECIFICATION: SS

Group 1: Aluminum & magnesium

Group 2: Iron; nickel; cobalt

Group 3: Titanium

TEST RESULTS

PASS FAIL

VISUAL: [/] []

PENETRATION: [/] []

PULL STRENGTH: [/] [] PSI Reading: _____

The individual named above has been trained and is qualified in accordance with standard AMS-W-6858A, and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/03/12

QUALIFIER: SB